

Date: Monday, 10/23/2006 12:05:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29107
 Estimate Number : 11054
 P.O. Number : *N/A*
 This Issue : 10/23/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 28695
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06 10 23
 Comment : Est A06.09.13 New issue KJ/JLM

Drawing Name : NUT PLATE ASSEMBLY

Part Number : D2873045
 Drawing Number : D2873 REVA
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 10/30/2006

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0375X01000	6061T6 BAR
-----	--------------------	------------



Comment: Qty.: 0.2363 f(s)/Unit Total : 7.0875 f(s)
 6061T6 BAR
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x01.000)
 Identify for D2873-5
 Batch: *7101926*

ml 06/10/25 30

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 1.000" x 0.375" x 2.700" long

ml 06/10/25 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA and Dwg D2873
 Identify as D2873-5 Dwg Rev *A* Folio Rev *AA*

ml 06/10/25 30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/10/25 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:05:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 29107

Part Number: D2873045

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.G 06/10/06 30

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D2873

FF 06-11-03

30

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/03 30

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y 06/11/03 X30

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

ml 06/11/06 (X30)

10.0 MS20426AD46 Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 120.0000 Each(s)

Rivet

Pick;

Qty	Part Number	Description	Batch
4	MS20426AD4-6	Rivet	M2930

✓

11.0 MS21075L5 Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nut Plate

Pick;

Qty	Part Number	Description	Batch
2	MS21075L5	Nut Plate	M18136

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:05:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 29107

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

mlo06/11/06

(x30)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/26/06

(30)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51392

10/24/07

(30)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/26/07

(30)

Job Completion



11/26/07

Dart Aerospace Ltd

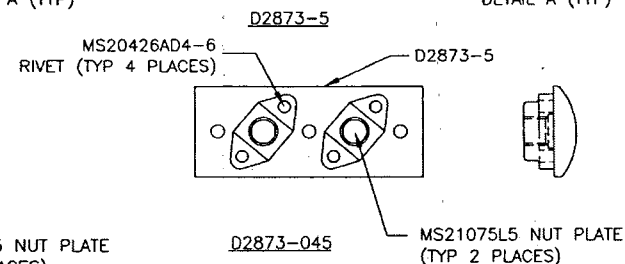
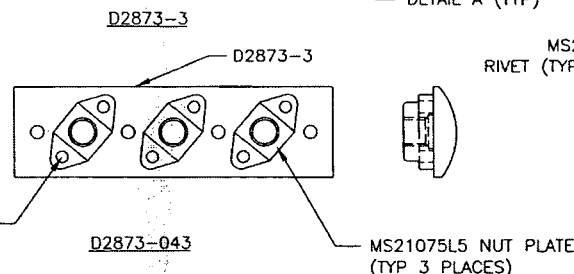
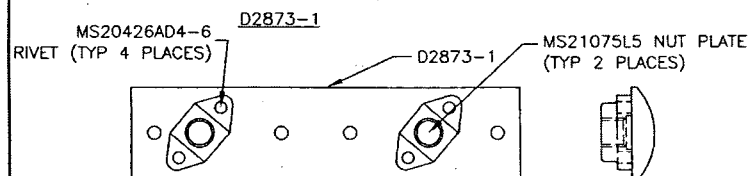
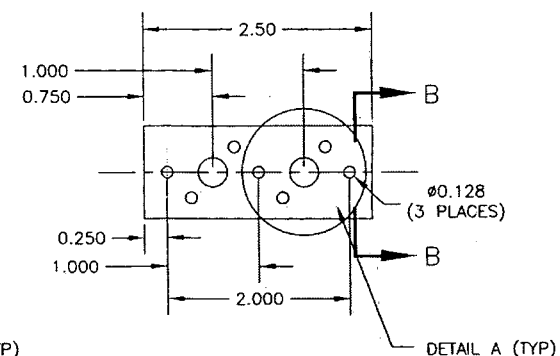
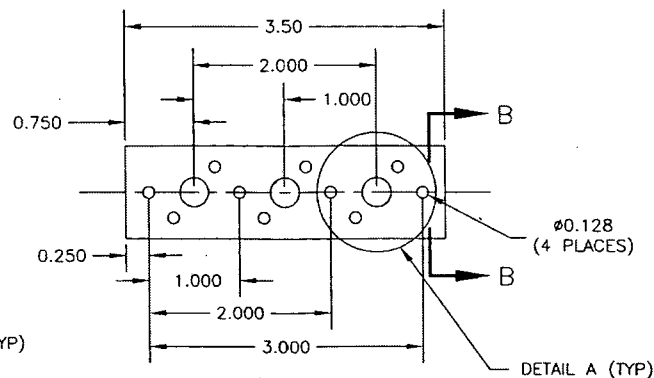
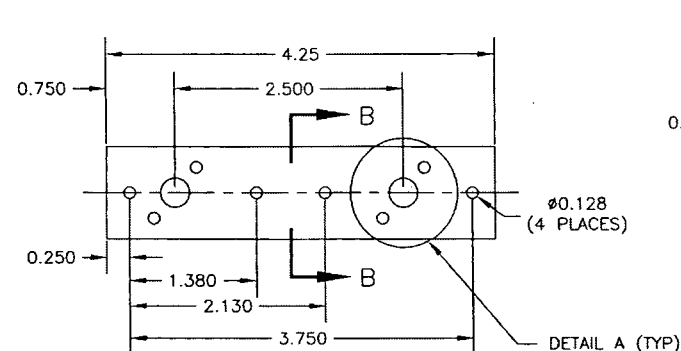
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-041

MS20426AD4-6 RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE (TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE (TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

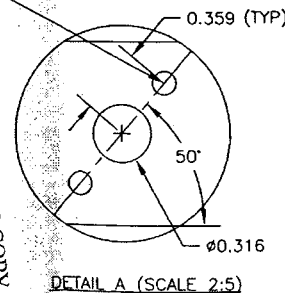
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

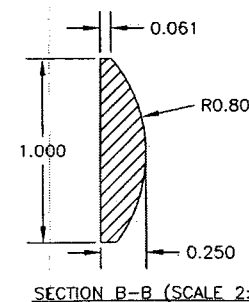
D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

(-041 4 PLACES)
(-043 6 PLACES)
(-045 4 PLACES)



DETAIL A (SCALE 2.5)



RELEASED
05-07-26

NO. 29107
WORK ORDER
UNCONTROLLED COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE
SUBJECT TO AMENDMENT

A	05.07.26	NEW ISSUE	
DESIGN	PH	DRAWN BY	PH
CHECKED	DS	APPROVED	DS
DATE	05.07.26	DRAWING NO.	D2873
		TITLE	RADIUS BLOCK
		REV. A	SHEET 1 OF 1
		SCALE	4:5